

Work Order ID 62813

Friday, October 08, 2010 12:45:11 PM



Page 1

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Item Name: Drag Arm

Stop



Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-10-8

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3463	Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to 13.875"
2-Deburr
3-Bend end as per dwg D3463

*= 7 m-l 10/10/12
SB 10/10/25*

(6x)

(6)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 10/10/26

(76)

120

0.00



Mill Conv

** Check your length before milling **
CONVENTIONAL MILLING MACHINE

Memo

Conventional Milling Machine

1-Mill as per dwg D3463
2-Drill hole & ream to 0.4385" as per dwg D3463
3-Deburr

11/05/16

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 62813

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Page 2

Item ID: D3463-7

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Stop



Item Name: Drag Arm

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

11/05/17

6

Memo

0.00

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

11/05/17

6

0

Memo

0.00

150



Small Fab

Small Fab

Small Fab

0.00

Memo

Grind .450" rad

0.00

6 0 M-L 11/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Friday, October 08, 2010 12:45:11 PM



Page 3

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Drag Arm

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5 mos 19

(x6)

Quality Control

170

Identify as per dwg & Stock Location: *w/A*

0.00



Packaging

Memo

0.00

EL 11-5-19

(x6)

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/5/24

Quality Control

ME 11-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 2:31:11 PM

Page 1

Work Order ID: 62813

Parent Item: D3463-7

Parent Item Name: Drag Arm



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.120

Purchased

No

f

42.7012

1.15625

1.15625



M-L 10/10/12

304 ss round tube .750 x .120w

Location

Loc Qty

Loc Code

MAT

42.7012

114706 ✓

42.7012

1.15625

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED

SUBJECT

DART

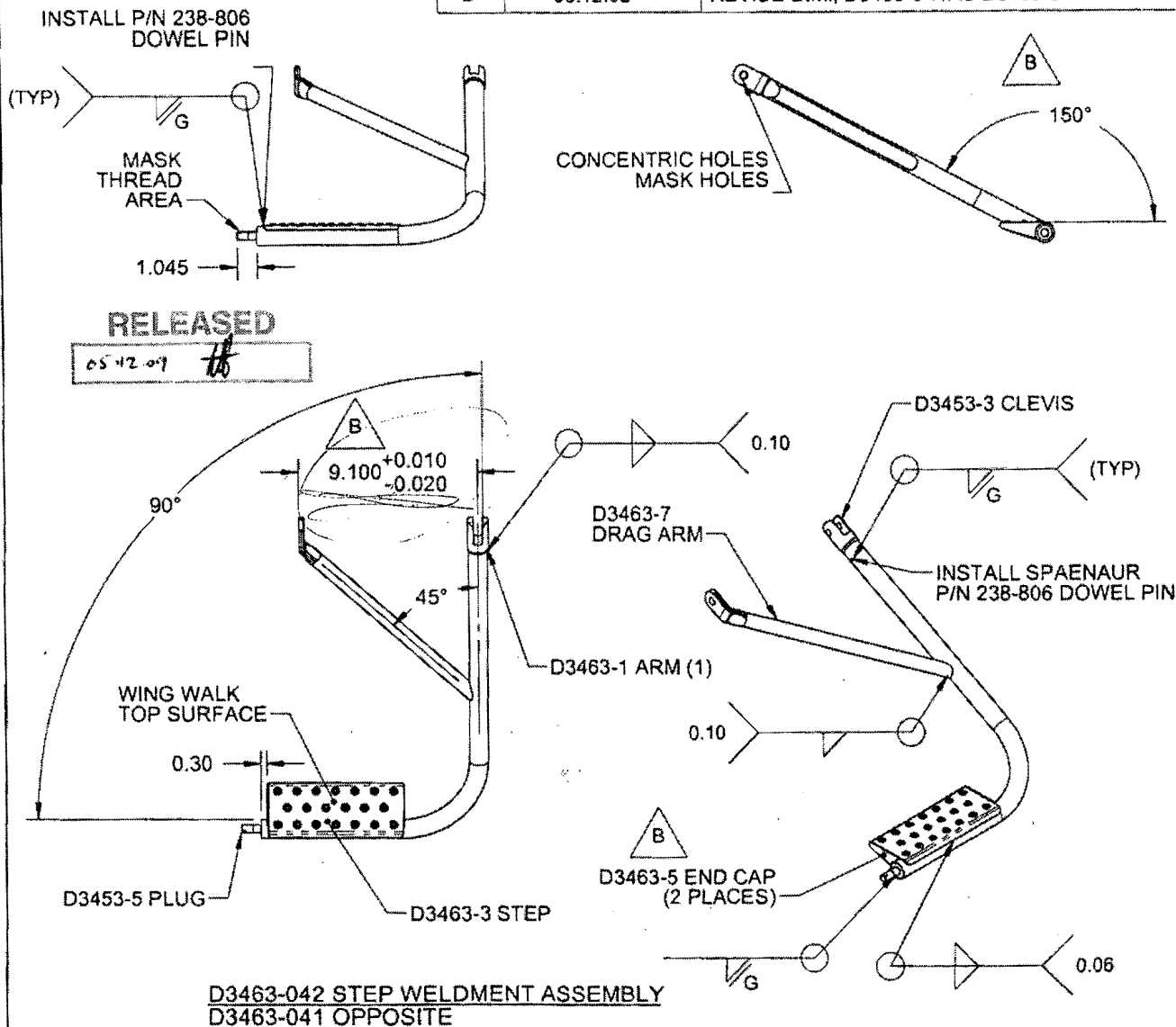
WITHDRAWN

WORK ORDER

NO. *62813*

110-1008

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



**D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE**

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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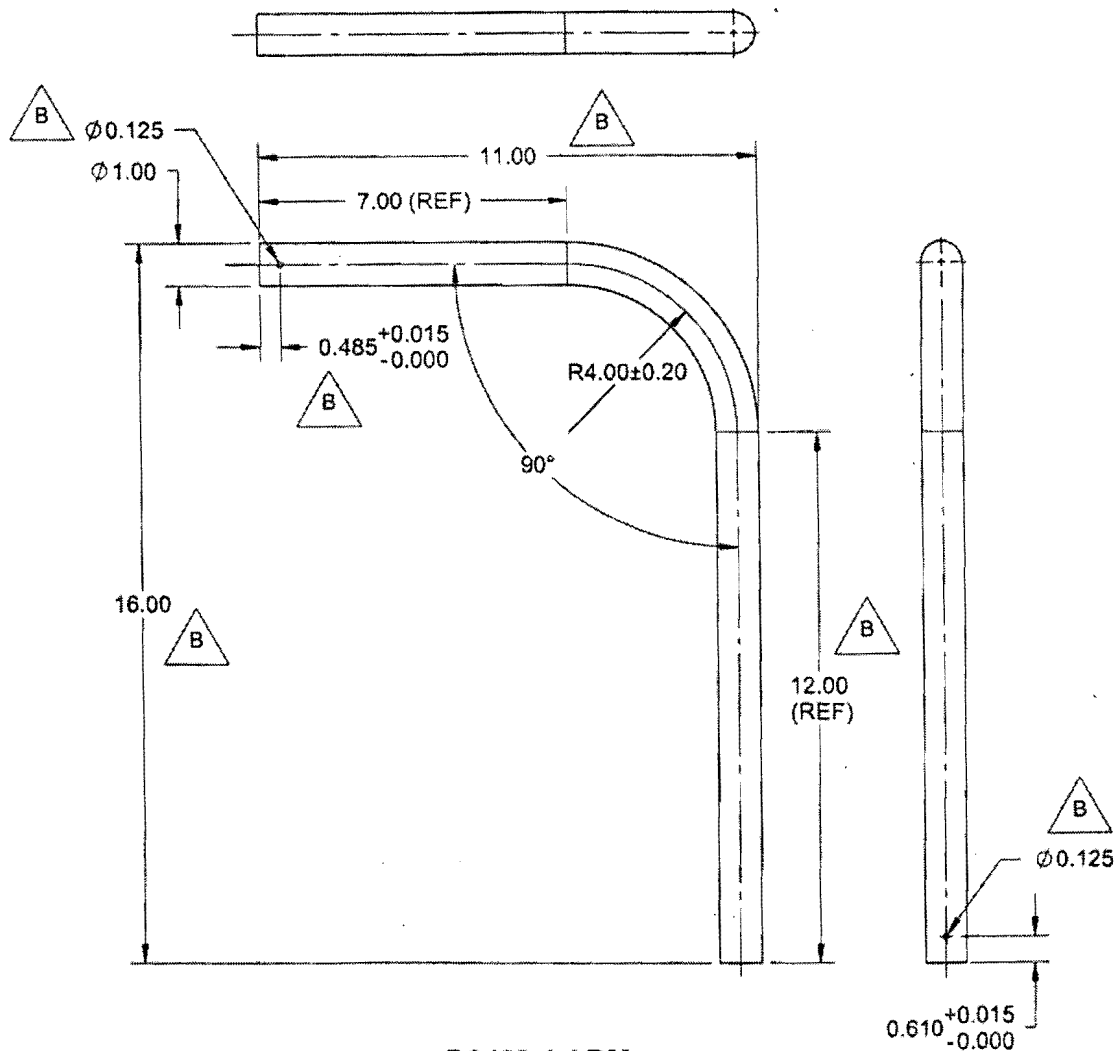


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 [Signature]

W/O 62813



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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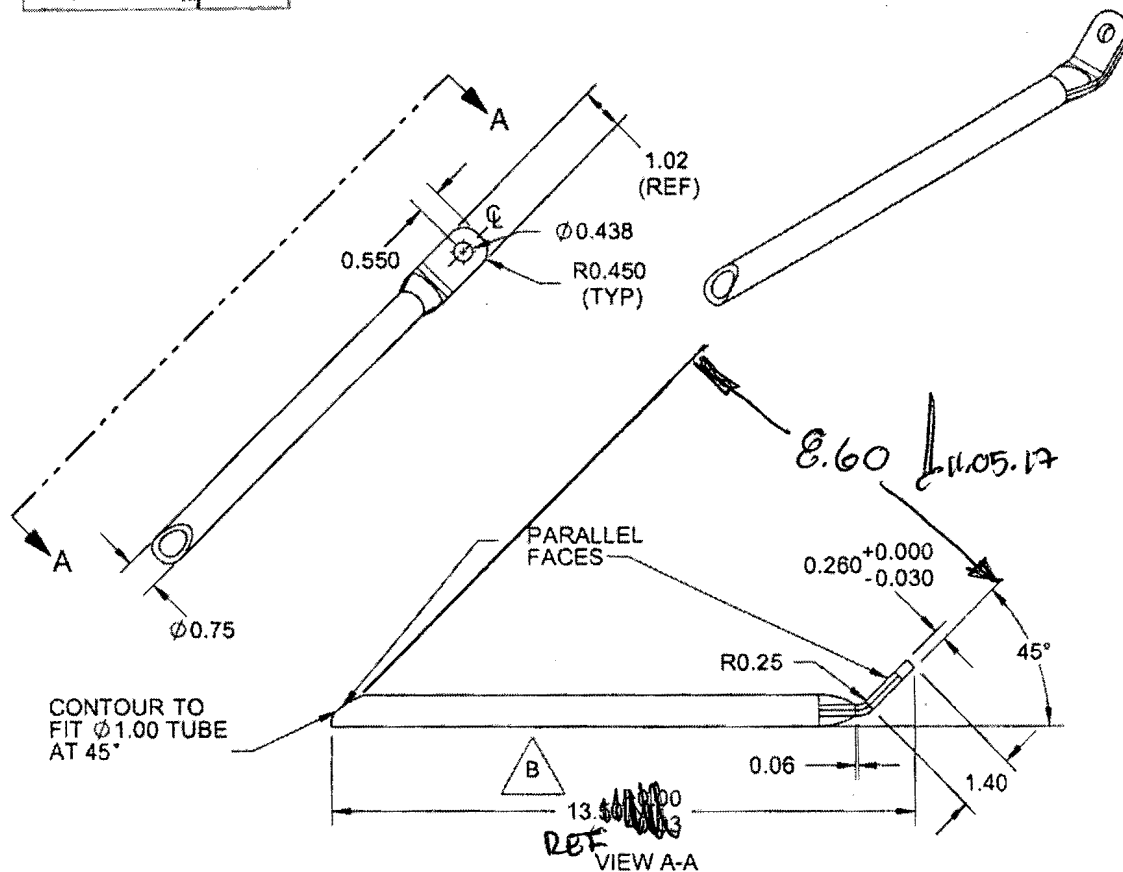


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05

U/O 42813



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
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